

Work Order ID 54353

December 8, 2009 9:51:03 AM



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Item ID: D412-724-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Head Rest Assembly, Center

Start Date: 08/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 15/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: *BP*

Date: *09/12/09*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

If D412-724-041 is a W/O on it's own, ☐ Photocopy bluefile and create labels per
PPP D412-724-041 CHG001

Labels only

10/6/09

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-1-22

(X) 100

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

⇒ 10/6/09

(X) 70

counted

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D412-724-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Head Rest Assembly, Center

Start Date: 08/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 15/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-724

041 ☐ Location: _____ ☐ PPP Rev: _____

DRAFT

R 14-1/25 (20)

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

10/01/25
MF 10-1-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 54353

Parent Item: D412-724-041

Parent Item Name: Head Rest Assembly, Center

Comments:

Start Date: 08/12/2009

Required Date: 15/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN525-10R6

24

Purchased

No

120

Each

110.0000

80.0000

Screw

Sx20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

110

101203

110

D3303-041

21

Manufactured

No

120

Each

3.0000

20.0000

Head Rest

Sx20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3

44448

3

D3304-041

21

Manufactured

No

120

Each

4.0000

20.0000

Tube Assembly

Sx20

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4

44354

4

M113595 sl 10-1-22

10-1-22 sl
B 54369 10-1-25

4
18x
B 54379 10-1-22 sl

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

3.0 INSTALLATION PROCEDURE

To install a Dart Head Rest Assembly:

- 3.1 If installed, remove the existing Head Rest Assembly by pulling the quick release pin that attaches it to the seat. Make note of the installation position (if applicable).
- 3.2 Inspect the seat for damage in the vicinity of the Head Rest Assembly. Consult the Aircraft Maintenance Manual for disposition if damage is observed.
- 3.3 If only replacing the Head Rest with the equivalent Dart D3303-041 Head Rest, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble D3303-041 Head Rest with existing Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.4 If only replacing the Tube Assembly with a Dart D3304-041/-043/-044 Tube Assembly, separate the existing Head Rest from the existing Tube Assembly by undoing 4 screws. Re-assemble existing Head Rest with Dart D3304-041/-043/-044 Tube Assembly by installing 4 screws and tightening to 15-25 in lb.
- 3.5 Slide the new or modified Head Rest Assembly into the seat tube and lock in place at the same location that the old Head Rest Assembly was installed (if applicable) using the quick release pin. Ensure pin is properly engaged.

4.0 WEIGHT AND BALANCE

There is negligible weight change associated with the installation of the Dart Head Rests.

5.0 PARTS LIST

QTY -011	QTY -041	QTY -043	QTY -044	Part Number	Description
X				D412-724-011	Dart Replacement Head Rest Kit, for 205/212/412
2	X			D412-724-041	Head Rest Assembly, Center
1		X		D412-724-043	Head Rest Assembly, LH
1			X	D412-724-044	Head Rest Assembly, RH
	1	1	1	D3303-041	Head Rest
	1			D3304-041	Tube Assembly
		1		D3304-043	Tube Assembly
			1	D3304-044	Tube Assembly
	4	4	4	AN525-10R6	Screw